

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001273**Date Inspected:** 17-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi, Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Caltrans mock up**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Dan Hernandez was present to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 89M tower mock up SMAW			In Progress
<p>ZPMC Quality Control (QC) Certified Welding Inspector (CWI) Mr. Chen Xi and Xu Le Feng were observed monitoring welding activities at the workstation. Caltrans QA Inspector observed SMAW in progress of fill passes on 89m tower mock up sub assembly MUSB-MA22 to SA13, weld joints MUB-MA21 A/J 49 and MUSB-MA22 to P213, weld joints MUB-21 G/J 39, 40, and 42. The weld joints are T-joint fillet welds in the 3F position. The approved welders Liang Yanhai # 066457, Fu Yanjie # 066268 and Xu Changxue #066002 were using approved welding procedure specification WPS-B-P-2113. Caltrans QA Inspector observed QC Chen Xi verify welding parameters. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. SMAW welding consumable is verified and identified as classification E7018 TL508 4mm in diameter. An electrode oven was observed by Caltrans QA Inspector in use during the welding process. QA Inspector observed QC CWI Chen Xi incorrectly documenting piece marks on ZPMC daily weld log.</p>			

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2 89M tower mock up SAW

In Progress

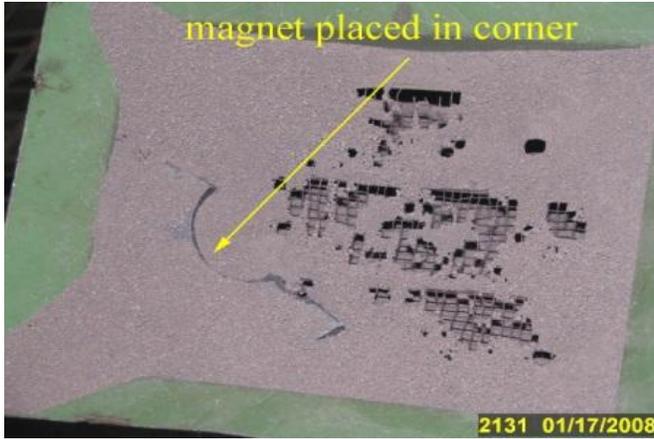
QA Inspector observed SAW in progress of fill passes on 89m tower mock up sub assembly MUSB-MA23 skin B to MUSB-MA24 Skin C; weld joint MUB-MA21 D/J 3B. The weld joint is a Complete Joint Penetration (CJP) corner joint welded in the 1G position. The approved welders Wu Zhibin # 049804 was using approved welding procedure specification WPS-B-T-2221-C-U2-BS. Caltrans QA Inspector observed QC Xu Le Feng verify welding parameters. Preheat and interpass temperatures were verified during welding activities and were within approved WPS minimum range and maximum range. SAW welding consumable is verified and identified as classification EM12K JW-3, 4.8mm diameter with JF-B flux.

QA Inspector observed the magnet in the flux hopper was placed against the side, when QA Inspector took photograph of this condition QC Inspector moved magnet to the center of the hopper.



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Summary of Conversations:

QA Inspector informed QC CWI Chen Xi that he was incorrectly documenting piece marks on his daily weld log.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Hernandez, Dan

Quality Assurance Inspector

Reviewed By: Cuellar, Robert

QA Reviewer